E

Item ID:

D3136-043

Accept

Setup Start

Stop



Revision ID:

Item Name:

Window Assembly

Start Date: Required Date 11/23/2009

11/16/2009 Start Otv: 6.00 **Req'd Qty:** 6.00

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan: MF Date: 09-11-13 Tooling:

Date:

Run

Start



QC: \_\_\_\_\_ Date: SPC (Y/N):

Date:

Stop

|--|

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3136	Rev E				4					
100			0.00							
	FLOW WATER JET							. 107	9-11-16	
Waterjet	Memo	F	0.00						7-11-16	
FLOW CNC Waterjet									,	
		E							(	3)
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							

! {BB| 6} {{B}| {| 1886| | 1884| | 1984| {| 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 1884| | 18 OC

Quality Control

0.00

1B9-11-16

120

OC

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00 => 5 or /n /16

Dart Aerospace Ltd	ı
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W/O:			V	ORK ORDER CHANG	ES			
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date G	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA: _	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	ANCE (NCF	3)		
DATE	STEP	Description of NC	Initial	Corrective Action Section		Verificati	on Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date		Chief Eng	QC Inspector
			i				İ	
			1				į	1

#### Work Order ID 53726

November 13, 2009 1:52:40 PM



Page 2

Item ID:

D3136-043

Accept

Setup Start

Stop



**Revision ID:** 

Ε Item Name: Window Assembly

**Required Date: 11/23/2009** 

**Start Date:** 

11/16/2009

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Stop

Start

Sequence ID/ Work Center ID

130

Thermoform

**Operation** Description Set Up/ **Run Hours** 

Draw Number Draw Rev.

Date:

Plan Accept Code Qty

Reject Qty

Reject Insp. Number

De 09/4/16

Stamp

THERMOFORMING MACHINE

Memo

0.00

0.00

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA002□Dwg

Rev. 

| Folio Rev.

□2- Engrave Part # and

Batch #, and affix labels □ (D3136-3)

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

the ogliffe XP

150

Quality Control

QC8- Inspect parts - second check

Memo

0.00

Dart A	Aerosi	pace	Ltd
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W/O:	]		VV	ORK ORDER CHANG	ES			•
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	lo DQA:	Date: _	
	R	esolution:					Date: _	
NCR:	J.,	V	ORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Officer Ling	Office Ling	Date			
·			1					
WATE 5	<u>L</u>							

### Work Order ID 53726

November 13, 2009 1:52:40 PM

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Page 3

Item ID:

D3136-043

Accept

Setup Start

Stop



**Item Name:** 

**Revision ID:** 

**Start Date:** 

**Required Date: 11/23/2009** 

11/16/2009

Window Assembly

Start Qty: 6.00

Req'd Qty: 6.00

**Cust Item ID: Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:\_\_\_\_\_

Date:

Draw

Rev.

Plan

Code

Start

Stop

Reject

Qty

Sequence ID/

Work Center ID

160

Thermoform Thermoforming Machine

Operation Description Set Up/ **Run Hours** 

0.00

0.00

HAND FINISHING THERMOFORMING

Memo

Water sand and buff to remove scractches as required

Date:

Run

Accept

Qty

Insp.

Stamp

Wh 09/4/16

Reject

Number

170

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:

180

Packaging

Packaging

Memo

Memo

0.00

0.00

9/4/16 (3x)

Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	es No	DQA:	Date:	
		esolution:		on:					
NCR:	• • • • • • • • • • • • • • • • • • • •	V	VORK OR	DER NON-CONFORMA	ANCE (N	CR)			
DATE	STEP	Description of NC			ion B	Ve	rification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector
		,							
			1						

### Work Order ID 53726

November 13, 2009 1:52:40 PM



Page 4

Item ID:

D3136-043

Accept



Setup Start



**Revision ID:** 

Item Name: Window Assembly

**Start Date:** 

11/16/2009

Start Qty: 6.00

**Required Date:** 11/23/2009

Ε

Req'd Qty: 6.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

A	nr	ro	vя	le	•	

QC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Stop



Sequence ID/

**Work Center ID** 

190

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Draw Number Draw Rev.

Plan Qty Code

Reject Accept Qty

Reject Number Stamp

Insp.

Quality Control

Memo

0.00

09/11/17 H MF 09-11-16

<b>Dart Aeros</b>	pace Ltd
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W/O:		· · · · · · · · · · · · · · · · · · ·	V	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			1							,
							4			
Part No		PAR #:	1	tegory:	_ NCF	R: Yes I	No DQA:		Date:	
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:		W	ORK OR	DER NON-CONFORM	ANCE	(NCR)	)	•		
DATE	STEP	Description of NC			tion B	C! 0	Verificat		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector
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		, ·								

## **Picklist Print**

November 13, 2009 1:52:40 PM

Work Order ID: 53726

Parent Item:

D3136-043RevE

Parent Item Name: Window Assembly



**Start Date:** 11/16/2009

**Required Date:** 11/23/2009

Page 1

Comments:								S	start Qty: 6.00		Required Qty:	6.00
	-	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9RevB1		Manufactured	No			100	Each	792.0000	12.0000			
				Warehou	_	Loc	<u>Oty</u>	Loc Code				٠.,
				<u>Loca</u>								1/
				Main Wa	rehouse						al a	0/./2/8
				ST			792			_6_	H. c	19/11/16/
					34554		304		_			
					46546		488					•
MACRLICS.125		Purchased	No			170	sf	128.7570	23.4000	12.	•	
		_										<b>a</b> -
1/8" Polycast II Sheet										·	B.A	-11-16
				Warehou	ise	Loc	Otv	Loc Code				
				Loca			<del></del>					
				Main Wa								

<b>Warehouse</b>	Loc Qty	Loc Code		
<u>Location</u>				
Main Warehouse	•			
MAT	128.757			(3
110115	4			
110633	17.2295	**		
111711	67.7447	* .	· · <u></u>	
112888	39.7828		112888	

# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	GES						
DATE STEP		PROCEDURE CHANGE			В	By Date		te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			-								
Part No	:	PAR #:	Fault Cate	egory:	NCR: \	es N	o <b>DQ</b> A	<b>\</b> :	_ Date: _		
	R	esolution:	Disposition	Disposition: QA: N/C Cld				osed: Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	ICR)					
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section   Initial   Action Description		gn &	Verification Section C		Approval	Approval QC Inspector	
<del> </del>		Gection	Chief Eng	Chief Eng		Date	Secu		Chief Eng	QC inspector	

DART AEROSPACE LTD	Work Order:	53736		
Description: Window Assembly	Part Number:	D3136-043		
Inspection Dwg: D3136 Rev: E		Page 1 of 1		

### FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

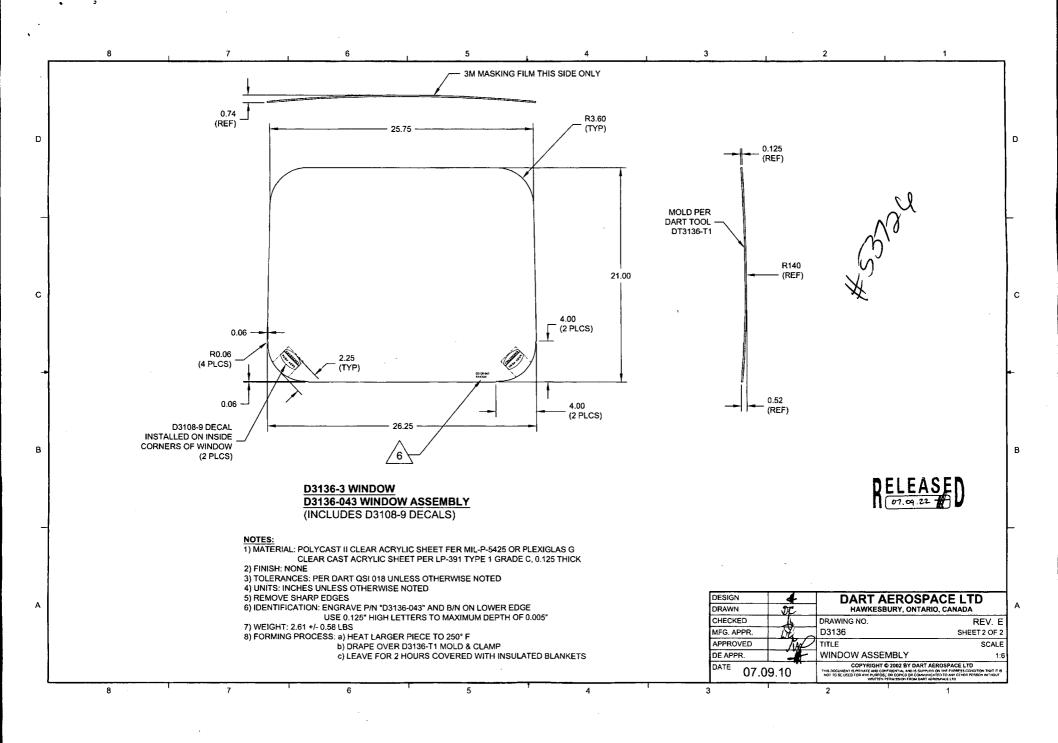
Drawing Dimension	Tolerance	Actual Dimension	Accept		Reject	Method of Inspection	Comments
21.00	+/-0.030	21.00	4 /	Sh.			
25.75	+/-0.030			$\mathcal{L}$			
26.25	+/-0.030	26.23		وأ	i		
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					<u> </u>		
					٠		

Measured by:	(B)	Audited by:	8	Prototype Approval:	N/A
Date:	9-11-66	Date:	orlule	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.19	New Issue	KJ/EC/DD 💉	<b>X</b>

Dart Aerospace	Ltd
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W/O:			ES				***			
DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			3711							·
Part No	Part No: PAR #:		Fault Categ	ory:	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition:			N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)			
DATE	STEP	Description of NC Corrective Action			Section B			Verification Approval		Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES		· ·		•			
DATE	STEP	PRO	PROCEDURE CHANGE			у	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			İ									
Part No: PAR #:		Fault Cat	egory:	_ NCR: \	es N	o <b>DQA:</b> _	Date: _					
Resolution:			Dispositi	Disposition: Q			QA: N/C Closed: Date:					
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (N	ICR)						
DATE	STEP	STEP Description of NC Section A	Corrective Action   Section B			gn &	Verification		Approval			
			Chief Eng	Chief Eng		Date	Section C	Chief Eng	QC Inspector			
								£				